



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-630-034
Job Sheet 188621



Part No: D412-630-034

Job Qty: 1 ea

Part Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

607729

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/5/19	0.00	0.00	Start Up Small Fab-4	9-89	DAN 24 2019
110	Small Fab	1 pcs		2/5/19	0.00	0.45	Small Fab-6	36	36
120	QC	1 pcs		2/5/19	0.00	0.00	QC5	9-89	19.04.11
130	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging1-4		
140	QC	1 pcs		2/5/19	0.00	0.00	QC4	21	FEB 20 2019
145	DC	1 pcs		2/5/19	0.00	0.00	DC	21	FEB 20 2019
150	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging3-2	21	FEB 20 2019
160	QC21-FG	1 Ea		2/5/19	0.00	0.00	QC21	21	FEB 20 2019

Part Op 110 - Assemble as per dwg D412-630 p.14

Descriptions: 145 - Photocopy bluefile & create labels per PPP D412-630-034 CHG005

150 - Identify and pack for shipping as per PPP D412-630-034 PPP Rev:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	2 Ea (2 ea)	90-Start up Operation	5103998
AN3C21A	Bolt	1 Ea (1 ea)	90-Start up Operation	5006260
AN8C16	Bolt	2 Ea (2 ea)	90-Start up Operation	5074164
D2012-107	Clevis	1 pcs (1 ea)	90-Start up Operation	5040916.2
D2803-042	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	5148131
D2804-042	RH Step Fwd Bracket	1 pcs (1 ea)	90-Start up Operation	50601583
D2807-041	Prop Assembly	2 Ea (2 ea)	90-Start up Operation	5141818
D2813	Washer	2 pcs (2 ea)	90-Start up Operation	5041174
D3395-1	Bushing	4 pcs (4 ea)	90-Start up Operation	5041201
D3562-042	Step Weldment	1 pcs (1 ea)	90-Start up Operation	5149615
D3672-15	Phenolic Washer	5 pcs (5 ea)	90-Start up Operation	5042894
D3672-19	Phenolic Washer	4 pcs (4 ea)	90-Start up Operation	5148025
D3672-7	Washer, Phenolic	4 pcs (4 ea)	90-Start up Operation	5131568
MS21043-3	Nut	4 Ea (4 ea)	90-Start up Operation	5143714
MS24665-302	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	51355672-1
MS24693-C280	Screw	2 Ea (2 ea)	90-Start up Operation	5137594
MS24693-C285	Screw	1 Ea (1 ea)	90-Start up Operation	51355672-30
AN44C7A	Eyebolt	1 Ea (1 ea)	130-Packaging	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
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DART Aerospace Ltd.
 1270 Aberdeen Street
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 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S151250
Part: D412-630-034
Job No: 188621
Serial No/Batch: S151250

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH96-69 Issue 7 of 7

Environmen
 Design
 Doc/Data
 Equip/Tooling
 Handling/Pre
 Material
 Internal Transport
 Tribal Knowledge
 LOA
 Substation
 Past Expiry Date
 Misidentified

Past Due ☐

OTHER : _____

AN4C10A	Bolt	1 Ea (1 ea)	130-Packaging
AN4C15A	Bolt	2 Ea (2 ea)	130-Packaging
AN4C6A	Bolt	1 Ea (1 ea)	130-Packaging
AN5C15A	Bolt	2 Ea (2 ea)	130-Packaging
D2806-1	Bushing	2 pcs (2 ea)	130-Packaging
D2806-3	Bushing	2 pcs (2 ea)	130-Packaging
D2810-5	Strut	1 pcs (1 ea)	130-Packaging
D3396-1	Spacer	2 pcs (2 ea)	130-Packaging
D3672-17	Phenolic Washer	7 pcs (7 ea)	130-Packaging
D3672-5	Washer, Phenolic	7 pcs (7 ea)	130-Packaging
MS21043-4	Nut	4 Ea (4 ea)	130-Packaging
MS21043-5	Nut	3 Ea (3 ea)	130-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	2	29	0
	AN3C21A	1	23	0
	AN8C16	2	15	0
	D2012-107	1	25	0
	D2803-042	1	2	0
	D2804-042	1	2	0
	D2807-041	2	8	0
	D2813	2	18	0
	D3395-1	4	46	0
	D3562-042	1	0	0
	D3672-15	5	544	0
	D3672-19	4	172	0
	D3672-7	4	1,115	0
	MS21043-3	4	880	0
	MS24665-302	2	18	0
	MS24693-C280	2	72	0
	MS24693-C285	1	56	0
130-Packaging	AN44C7A	1	18	0
	AN4C10A	1	35	0
	AN4C15A	2	56	0
	AN4C6A	1	399	0
	AN5C15A	2	63	0
	D2806-1	2	3	0
	D2806-3	2	11	0
	D2810-5	1	7	0
	D3396-1	2	33	0
	D3672-17	7	73	0
	D3672-5	7	535	0
	MS21043-4	4	679	0
	MS21043-5	3	140	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																												
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D412-630-034
Job Sheet 188621



057744

Part No: D412-630-034

Job Qty: 1 ea

Part Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

Bill of Materials

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
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90	Start up Operation	1 Ea	1/25/19	2/5/19	0.00	0.00	Start Up Small Fab-4		DAS 6 3-89 IAN 24 2019
110	Small Fab	1 pcs		2/5/19	0.00	0.45	Small Fab-6		
120	QC	1 pcs		2/5/19	0.00	0.00	QC5		
130	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging1-4		
140	QC	1 pcs		2/5/19	0.00	0.00	QC4		
145	DC	1 pcs		2/5/19	0.00	0.00	DC		
150	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging3-2		
160	QC21-FG	1 Ea		2/5/19	0.00	0.00	QC21		

Part Op 110 - Assemble as per dwg D412-630 p.14

Descriptions: 145 - Photocopy bluefile & create labels per PPP D412-630-034 CHG005

150 - Identify and pack for shipping as per PPP D412-630-034 PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	2 Ea (2 ea)	90-Start up Operation	
AN3C21A	Bolt	1 Ea (1 ea)	90-Start up Operation	
AN8C16	Bolt	2 Ea (2 ea)	90-Start up Operation	
D2012-107	Clevis	1 pcs (1 ea)	90-Start up Operation	
D2803-042	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	
D2804-042	RH Step Fwd Bracket	1 pcs (1 ea)	90-Start up Operation	
D2807-041	Prop Assembly	2 Ea (2 ea)	90-Start up Operation	
D2813	Washer	2 pcs (2 ea)	90-Start up Operation	
D3395-1	Bushing	4 pcs (4 ea)	90-Start up Operation	
D3562-042	Step Weldment	1 pcs (1 ea)	90-Start up Operation	
D3672-15	Phenolic Washer	5 pcs (5 ea)	90-Start up Operation	
D3672-19	Phenolic Washer	4 pcs (4 ea)	90-Start up Operation	
D3672-7	Washer, Phenolic	4 pcs (4 ea)	90-Start up Operation	
MS21043-3	Nut	4 Ea (4 ea)	90-Start up Operation	
MS24665-302	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	
MS24693-C280	Screw	2 Ea (2 ea)	90-Start up Operation	
MS24693-C285	Screw	1 Ea (1 ea)	90-Start up Operation	
AN44C7A	Eyebolt	1 Ea (1 ea)	130-Packaging	5019401
AN4C10A	Bolt	1 Ea (1 ea)	130-Packaging	PM136044.0
AN4C15A	Bolt	2 Ea (2 ea)	130-Packaging	5044216
AN4C6A	Bolt	1 Ea (1 ea)	130-Packaging	5100397
AN5C15A	Bolt	2 Ea (2 ea)	130-Packaging	PM137587.1
D2806-1	Bushing	2 pcs (2 ea)	130-Packaging	5146106
D2806-3	Bushing	2 pcs (2 ea)	130-Packaging	5034003x1 5137400x1
D2810-5	Strut	1 pcs (1 ea)	130-Packaging	5044351
D3396-1	Spacer	2 pcs (2 ea)	130-Packaging	5144111
D3672-17	Phenolic Washer	7 pcs (7 ea)	130-Packaging	PM150866
D3672-5	Washer, Phenolic	7 pcs (7 ea)	130-Packaging	F153354x5 F153354-25x 2
MS21043-4	Nut	4 Ea (4 ea)	130-Packaging	517759
MS21043-5	Nut	3 Ea (3 ea)	130-Packaging	5099518

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	2	29	2
Allocated Container Detail				
	Qty	Container No	Location	Init
	2	S147842	st331	
	AN3C21A	1	23	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	s006260	st348	
	AN8C16	2	15	2
Allocated Container Detail				
	Qty	Container No	Location	Init
	2	S147843	st332	
	D2012-107	1	19	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S147844	st001	
	D2803-042	1	2	1

Allocated Container Detail			
Qty	Container No	Location	Init
1	S147856	st473	_____
D2804-042	1	2	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S147857	st474	_____
D2807-041	2	24	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147859	st011	_____
D2813	2	18	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147862	st011	_____
D3395-1	4	46	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147863	st033	_____
D3562-042	1	0	0
D3672-15	5	544	5
Allocated Container Detail			
Qty	Container No	Location	Init
5	S147864	st047	_____
D3672-19	4	172	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147866	st048	_____
D3672-7	4	989	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147868	st047	_____
MS21043-3	4	703	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147870	st302	_____
MS24665-302	2	18	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147871	st288	_____
MS24693-C280	2	72	2
Allocated Container Detail			
Qty	Container No	Location	init
2	S147872	st287	_____

MS24693-C285

1

56

1

Allocated Container Detail

130-Packaging

Qty	Container No	Location	Init
1	S147873	st287	
AN44C7A	1	18	0
AN4C10A	1	35	0
AN4C15A	2	56	0
AN4C6A	1	339	0
AN5C15A	2	63	0
D2806-1	2	23	0
D2806-3	2	31	0
D2810-5	1	19	0
D3396-1	2	33	0
D3672-17	7	73	0
D3672-5	7	535	0
MS21043-4	4	1,136	0
MS21043-5	3	123	0

Part Specifications

Specifications could not be found.

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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)